

Work Order ID 57625

Monday, April 12, 2010 8:55:49 AM

SHIP TODAY/TOMORROW



Page 1

Item ID: DSI 9342-013

Accept



Setup Start



Revision ID:

Stop



Item Name: Gusset Repair, Quick Release

Start Date: 4/12/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 4/12/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: mf Date: 10-4-12 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
DSI 9342	B

100 0.00



DC

Document Control

Memo

Photocopy bluefile & type labels per PPP DSI 9342-013
CHG001

0.00

5/10/12

HJ for BG 10/04/12

110 Pick Kit 0.00



Packaging

Packaging

Memo

0.00

10/4/12 (1)

120 QC4- 100% Inspect kits for completeness 0.00



QC

Quality Control

Memo

0.00

5/10/12

(A)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 57625

Monday, April 12, 2010 8:55:49 AM



Page 2

Item ID: DSI 9342-013

Accept



Setup Start



Revision ID:

Stop



Item Name: Gusset Repair, Quick Release

Start Date: 4/12/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 4/12/2010 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
	Packaging								
Packaging	Memo Identify and pack for shipping as per PPP DSI 9342-013 Location: _____ PPP rev: <u>A</u>	0.00							
140	QC21- Final Inspection - Work Order Release	0.00							
	QC								
Quality Control	Memo	0.00							

10/04/12 (1)

10/04/12

MF

10-4-12.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, April 12, 2010 8:55:48 AM

Page 1

Work Order ID: 57625

Parent Item: DSI 9342-013

Parent Item Name: Gusset Repair, Quick Release

Start Date: 4/12/2010

Required Date: 4/12/2010

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3929-041 x2 Gusset Assembly		Manufactured	No			110	Each	11.0000	2.0000			
---------------------------------	--	--------------	----	--	--	-----	------	---------	--------	--	--	--

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
WA	11	
56180	5	
57430	6	

D3929-042 x2 Gusset Assembly		Manufactured	No			110	Each	8.0000	2.0000			
---------------------------------	--	--------------	----	--	--	-----	------	--------	--------	--	--	--

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
WA	8	
56181	2	
57431	6	

BERS-020 Pip Pin		Purchased	No			110	Each	2.0000	4.0000			
---------------------	--	-----------	----	--	--	-----	------	--------	--------	--	--	--

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST284	2	
113565	2	

57430

57431

114350 2x

113565 2x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-607

REF. CANADIAN STC: SH94-14
REF. FAA STC: SR00213NY
REF. EASA STC: EASA.IM.R.S.01405


REFERENCE ONLY

IN CASES WHERE THE D2325 GUSSETS HAVE SUSTAINED CONSIDERABLE DAMAGE, DSI 9342-011/-013 REPAIR KITS CAN BE PROCURED FROM DART TO REWORK EXISTING D350-607-041/-043 BASKET BASES ONLY. D350-607-045/-047 BASKET BASES CANNOT BE REWORKED TO THIS PROCEDURE. REPLACE THE D2325 GUSSETS BY T.I.G. WELDING AS FOLLOWS:

- 1) CLEAN AREA OF PAINT, ETC...
- 2) REMOVE EXISTING D2325 GUSSET(S) AS SHOWN IN FIGURE 1.
- 3) INSTALL REPLACEMENT D3929-041/-042 GUSSETS BY T.I.G. WELDING PER MIL-STD-2219/AMS-STD-2219 CLASS 'C' USING ER308L FILLER ROD AS SHOWN IN FIGURE 2.
- 4) TOUCH UP PAINT IN ACCORDANCE WITH ICA-D350-607 REV 0.
- 5) WHEN BASKET BASE IS REPAIRED, LONGER BOLTS OR QUICK RELEASE PINS ARE REQUIRED TO INSTALL THE BASKET ON AIRCRAFT. SUBSTITUTE EXISTING HARDWARE USING PARTS LISTED BELOW.
- 6) ADJUST WEIGHT AND BALANCE IN ACCORDANCE WITH THE TABLE ON SHEET 4.

PARTS LIST

QTY. -011	QTY. -013	PART NUMBER	DESCRIPTION
X		DSI 9342-011	GUSSET REPAIR KIT
	X	DSI 9342-013	GUSSET REPAIR KIT, QUICK RELEASE
2	2	D3929-041	GUSSET ASSY, LH
2	2	D3929-042	GUSSET ASSY, RH
4		AN4-15A	BOLT (REPLACES AN4-12A)
8		AN960JD416	WASHER
	4	BLRS-020	QUICK RELEASE PIN (REPLACES BLRS-010)
4		MS21042L4	NUT

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01
APPROVED
BY: 
D. SHEPHERD (DE # 02)
DATE: 09.04.06
CERT. NO.: SH94-14
ISSUE NO.: 4

B	CREATION OF DSI KITS TO PROVIDE REPLACEMENT PARTS AND REQD HARDWARE. SEE NCR#09-042.	MB	09.04.06
A	NEW ISSUE	PH	06.07.10
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9342	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE WELD REPAIR	NTS
DATE	09.04.06	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries